

Work Order ID 69131

Tuesday, May 03, 2011 10:28:50 AM



Page 1

Item ID: D3023-1

Accept

Revision ID:

Item Name: Back Panel

Start Date: 5/3/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

WPF

Date:

11-05-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: *A*

Prog Rev: *A*

***grain direction along 28.100" ***

2-Deburr if necessary

B11-5-3

①

110

0.00



QC2-Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-3

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

8 11/05/13

Memo

0.00

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using
D3017-041 back frame

SB 11/05/14/12

11-5-17

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 11/05/17

Memo

0.00

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Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0	11	4/05/17
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 1:30 FINISH TIME: 2:00	0.00 0.00				1	0	11-5-17	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0	11	4/05/17

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>CA</u> Memo <u>ce/o 69118</u>	0.00 0.00							<u>EP 5/11/18</u> ①
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/5/18</u> ① <u>11-05-18</u> ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 10:28:48 AM

Page 1

Work Order ID: 69131



Parent Item: D3023-1



Parent Item Name: Back Panel

Start Date: 5/3/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

100

sf

46.5000

2.8777

3.029158



Bit 5-3

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

46.5

111699

0.5

113189

46

113189

①

DART AEROSPACE LTD		Work Order: 6913
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.132	✓		U 1802	
Ø0.191	+0.005/-0.001	.193	✓		V	
1.660	+/-0.010	1.658	✓		V	
0.375	+/-0.010	.379	✓		U	
1.340	+/-0.010	1.344	✓		V	
2.375	+/-0.010	2.372	✓		V	
0.375	+/-0.010	.379	✓		V	
25.28	+/-0.030	25.28	✓		T 1801	
27.03	+/-0.030	27.03	✓		T	
28.10	+/-0.030	28.10	✓		T	
1.30	+/-0.030	1.296	✓		V	
2.375	+/-0.010	2.376	✓		V	
8.711	+/-0.010	8.715	✓		T	
5.597	+/-0.010	5.593	✓		T	
8.57	+/-0.030	8.57	✓		T	
1.970	+/-0.010	1.971	✓		U	
7.42	+/-0.030	7.42	✓		T	
10.92	+/-0.030	10.92	✓		T	
14.75	+/-0.030	14.75	✓		T	

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 11-5-3	Date: 11/03/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

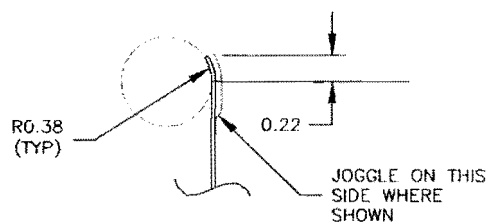
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

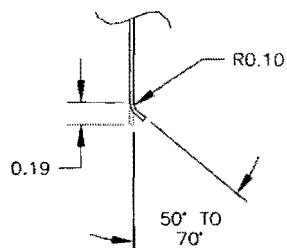
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SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

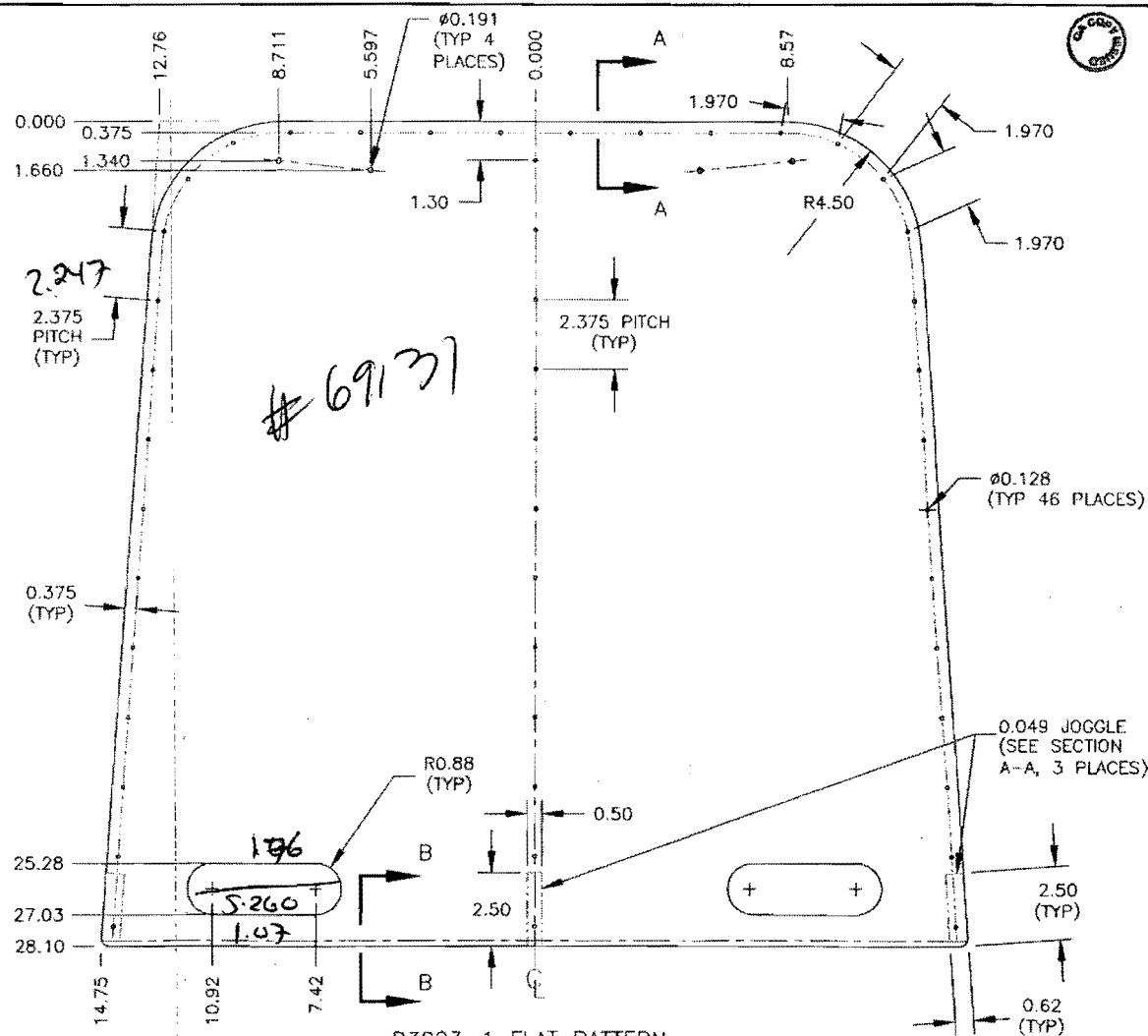


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

A		01.05.18	NEW ISSUE
DESIGN	✓	DRAWN BY	✓
CHECKED	✓	APPROVED	✓
DATE	01.05.18	TITLE	BACK PANEL
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